

205.633.011

SPLT

Dart Aerospace Ltd.

22

Date: Wednesday, 5/16/2007 1:29:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CLLDAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT  
 Job Number : 32389A  
 Estimate Number : 10176  
 P.O. Number : N/A Part Number : D2563  
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2563 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C  
 Previous Run : 32382A Material : N/A  
 Due Date : 5/30/2007 Qty: 8 Unit: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev G 02.07.31 Re-format Location RF

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description:

1.0 D2244-16 Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 02-8-216

2.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part No. Description

Batch

2 D2673-34 End Cap

332404

3.0 D2561 Lug Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part No. Description

Batch

2 D2561 Lug Plate

330384 = 16

4.0 D2564 Mounting Angle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part No. Description

Batch

2 D2564 Mounting Angle

330464



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slip 06/07 welding  
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32389A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

Q-m 07.06.22

2-Deburr ends

JK 07.06.25

3-Weld (1 End CAP LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343

JK 07.06.25

A/R AL ROD

Batch:

MIC 2756

MIC 4304

4-Grind

Q-m

07.06.26

6.0

QC5/9

WELD INSPECTION



QCS-207062710



Comment: WELD INSPECTION

ID 07.06.27

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q-m

07.06.28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JK 07.07.03

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

MIC 2756

MIC 4701

3-Grind

Q-m

07.07.04

JK 07.07.03

JK 07.07.03

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

NS07/07/04/10





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32389A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*2070704 (10)*

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*12104144*

*BR/M/L 070705*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

*MD/FR*

*0710705 (2)*

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*071706 (2)*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(2) 0710706*

Job Completion



*See w/o D205633025*

*32508*

*120706*

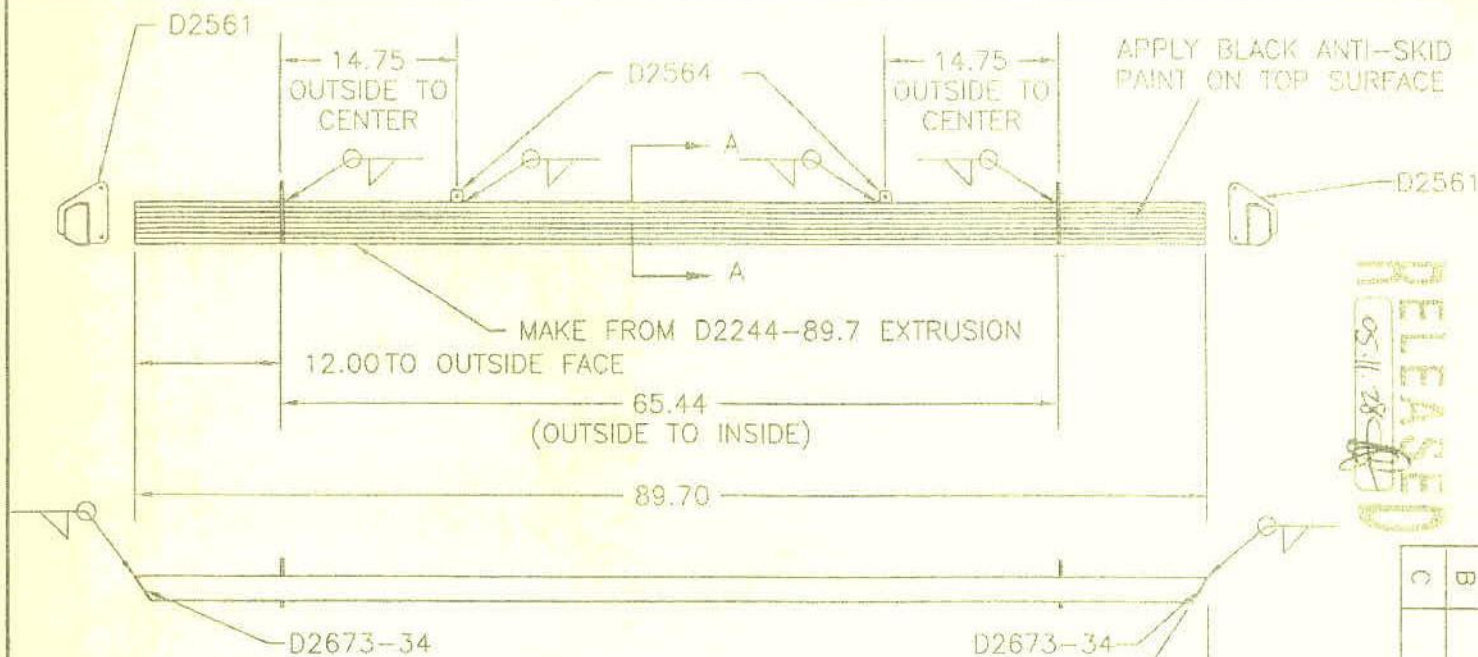




**DART**

RELEASED  
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	Pt	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2563
DATE	TITLE	REV. C
05.11.14	STEP WELDMENT ASSEMBLY	SCALE 1:1
A	NEW ISSUE	
B	END CAPS CHANGED (WAS D2246)	
C	UPDATE NOTES	



**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

\*cut per drawing

**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BOTTOM  
APPLYING BLACK ANTI SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

